

Date: Friday, 01/08/2008 10:43:04 AM
User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SUPPORT ASSEMBLY
Job Number :	40905		
Estimate Number :	10464		
P.O. Number :		Part Number :	D3278041
This Issue :	01/08/2008	Drawing Number :	D3278 REV.C
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	//	Drawing Revision :	C
Previous Run :	40346	Material :	
Written By :		Due Date :	15/08/2008
Checked & Approved By :	JLP 08.8.05	Qty:	40
Comment :	Est:A 04.04.19 New issue KJ/JLM	Um:	Each
	EST B 07.08.21 Chg rivet per PAR185		
	by: JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	40905A	SUPPORT
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Comment: Sub-Component SUPPORT

1 x D3278-1 Batch B36811

2.0	40905B	SUPPORT
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Comment: Sub-Component SUPPORT

1 x D3278-2 Batch B36811

3.0	D32783	Spacer
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s)

Spacer

Pick:

Qty	Part Number	Description	Batch
1	D3278-3	Spacer	<u>B40355</u>

4.0	MS20426AD36	Rivet
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 160.0000 Each(s)

RIVET

Pick:

Qty	Part Number	Description	Batch
4	MS20426AD3-6	Rivet	<u>M105055</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 01/08/2008 10:43:04 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT ASSEMBLY

Job Number: 40905

Part Number: D3278041

Job Number:



Seq. #: Machine Or Operation:

Description:

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Ph5

Comment: SMALL & MEDIUM FAB RESOURCE 1

Rivet spacers with support as per Dwg D3278.

EF 08/08/20 (40)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/20 (x40)

7.0

D22301

Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total: 80.0000 Each(s)

Mounting Lug

Pick: Packing Kit

Qty Part Number

2 D2230-1

Description

Mounting Lug

Batch

B40934

EF 08/08/27

8.0

AN413A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 80.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

2 AN4-13A

Description

Bolt

Batch

167959

SS 08/08/27 (40)

9.0

AN960JD416

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 160.0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number

4 AN960JD416

Description

Washer

Batch

M68161

SS 08/08/27 (40)

10.0

MS21042L4

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 80.0000 Each(s)

Nut

Pick: Packing Kit

Qty Part Number

2 MS21042L4

Description

Nut

Batch

M67499

SS 08/08/27 (40)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3278-041 PAR #: N/A Fault Category: Prod / MB PSS med + small NCR: Yes No DQA: A Date: 08/08/20
D350-591-311/32 QA: N/C Closed: D Date: 08/08/20

NCR: <u>40965</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/08/20	S.D	During inspection it was found that 1 assembly has 1 rivet installed incorrectly R.C. Rivet was compressed to thin.	[Signature]	Drill out incorrect rivet with extreme care care.	EB 08/08/20	[Signature]	[Signature]	[Signature]
				Replace MB 204264D 3-6 B# M16505	EB 08/08/20			
				Have QC inspect condition of hole prior to installing rivet	N/A			
			[Signature]	* After removing the rivet from D3278-2 it was found the hole was ovalized.	EP 08/08/20			
			[Signature]	Scrap and destroy and replace Qty 1 D3278-2 B# 36811				
			[Signature]	R.C. Rivet enlarge the hole.				

NOTE: Date & initial all entries

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Drawing Name: SUPPORT ASSEMBLY

Job Number: 40905

Part Number: D3278041

Job Number:



Seq. #: Machine Or Operation: Description :

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble support as per Dwg D3278.

DO NOT TIGHTEN BOLTS

Identify as D3278-041

08/08/27 (40)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/08/28 (40) *locates*

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location

8/8/28

X40
SP
40

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/27

Job Completion



h 08-08-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

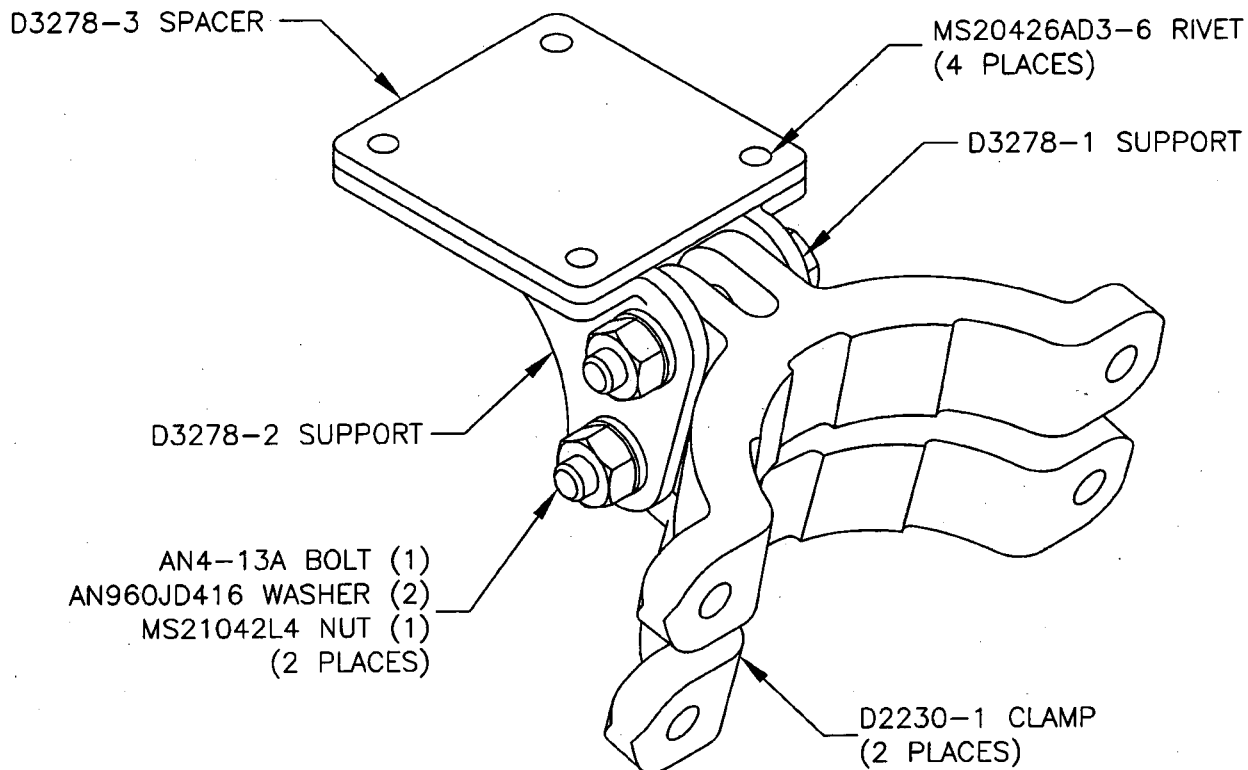
NOTE: Date & initial all entries

DART

DESIGN 97	DRAWN BY JC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

RELEASED
07-08-08

D3278-041 SUPPORT ASSEMBLY



Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

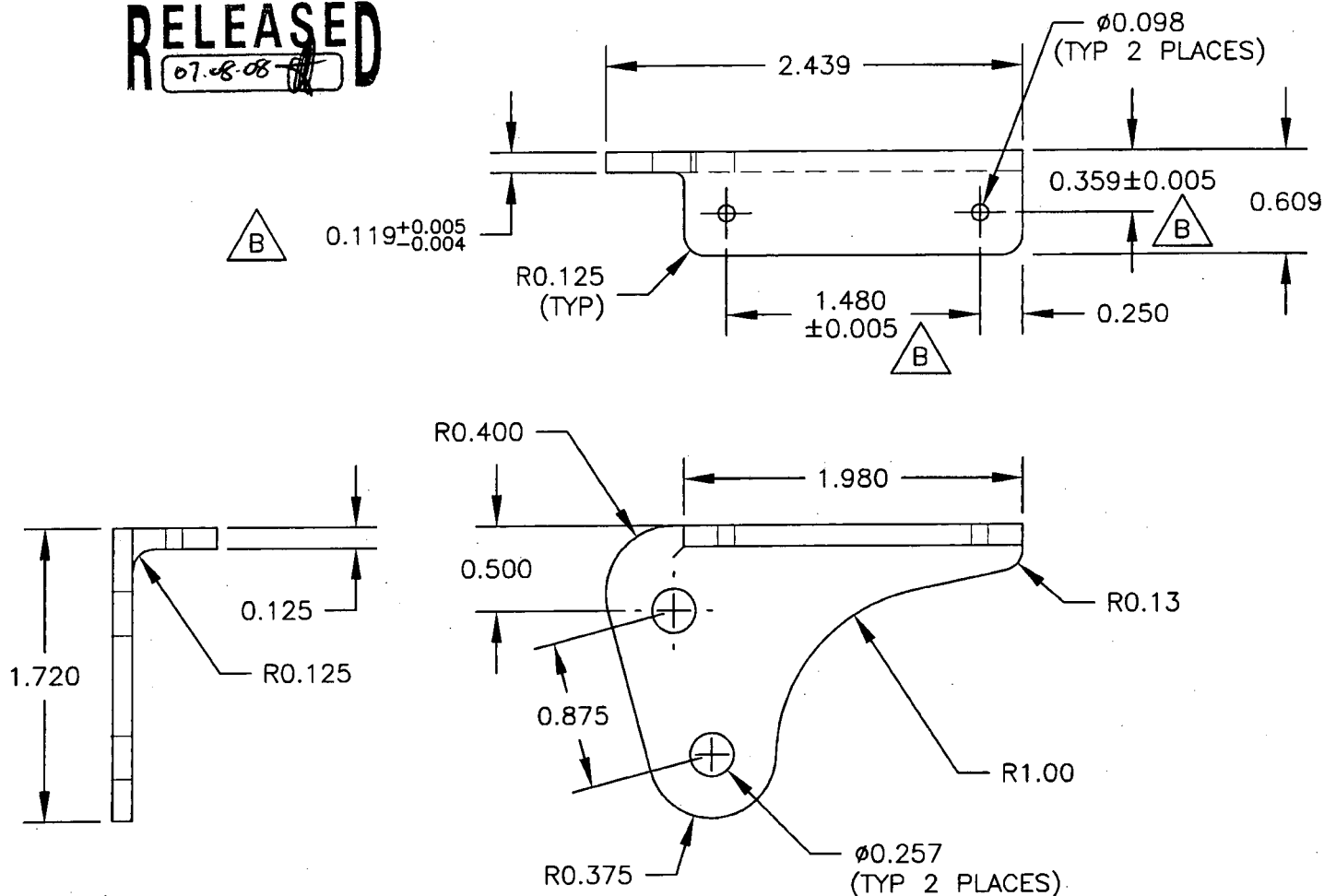
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DESIGN 901	DRAWN BY BC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24	TITLE SUPPORT ASSEMBLY		SCALE 1:1

RELEASED
07-08-08**D3278-1 SUPPORT (SHOWN)****D3278-2 SUPPORT (OPPOSITE)**

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)

- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

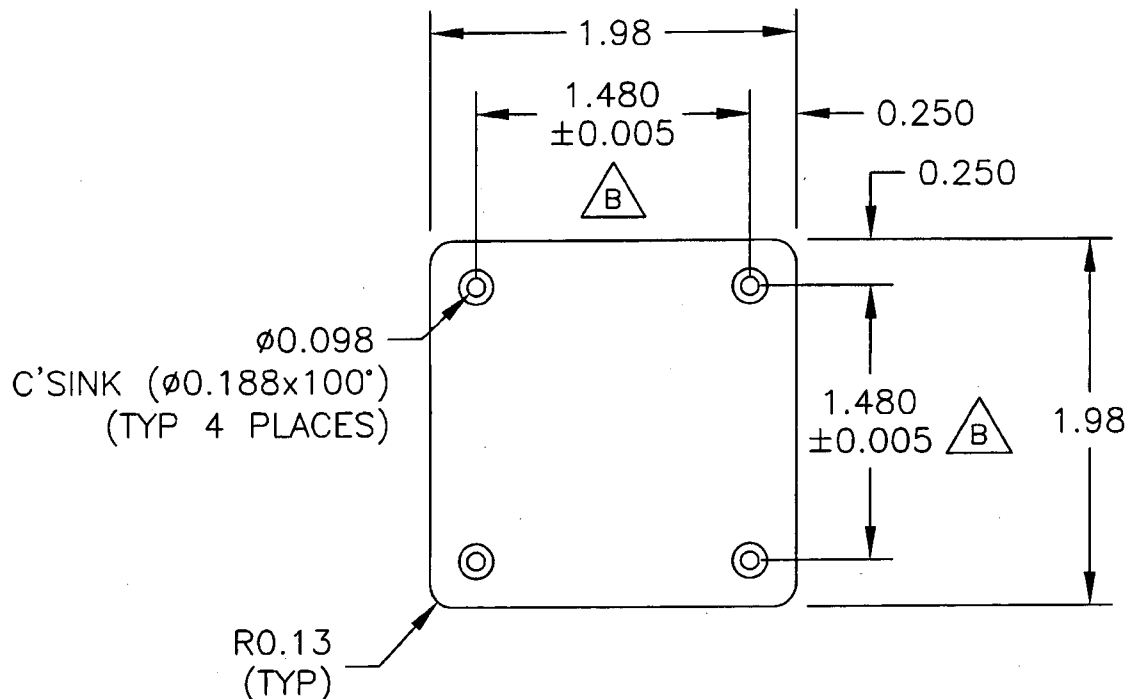
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DART

DESIGN <i>GP</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>JB</i>	APPROVED <i>JB</i>	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07.08.08**D3278-3 SPACER**

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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